



Dart Aerospace Ltd.
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Canada

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RBT400284-M Job Sheet 181872



005917

Part No: RBT400284-M

Job Qty: 12 ea

Part Name: Tail Rotor Balance Set



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/10/18

Job Tracking No:

Due Date: 10/10/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBT400284-M Rev. A IPP Rev. A 18.08.10 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	10/10/18	10/10/18	0.00	0.00	Start Up Small Fab-4		MCL
110	Small Fab	12 pcs	10/10/18	10/10/18	0.00	2.40	Small Fab-4		MCL
120	QC	12 pcs	10/10/18	10/10/18	0.00	0.00	QC5		SA
130	Packaging	12 pcs	10/10/18	10/10/18	0.00	0.00	Packaging3-1		SA
140	QC21-FG	12 Ea	10/10/18	10/10/18	0.00	0.00	QC21		21 OCT 17 2018

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-1600-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RBT400284-M-4 to RBT400284-M-3 foam as per DWG. 6-Glue foam to case and pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	48 Ea (4 ea)	90-Start up Operation	5075949
RB41011	Dart Tooling Placard, Aluminum	12 Ea (1 ea)	90-Start up Operation	502040
5274T77	Plastic Container	24 Ea (2 ea)	110-Small Fab	5105572
APP-1600-E	Case	12 Ea (1 ea)	110-Small Fab	5104653 - 5102945 - 5102946
RBT400284	Tail Rotor Balance Set	12 Ea (1 ea)	110-Small Fab	5104657
RBT400284-M-2	Bottom Foam	12 (1 ea)	110-Small Fab	5104652
RBT400284-M-3	Top Foam	12 (1 ea)	110-Small Fab	5107810
RBT400284-M-4	Content Placard	12 Ea (1 ea)	110-Small Fab	5107814
RBT400284-M-5	Location Placard	12 Ea (1 ea)	110-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	97524A032	48	583	0
	RB41011	12	805	0
110-Small Fab	5274T77	24	10	0
	APP-1600-E	12	1	0
	RBT400284	12	0	0
	RBT400284-M-2	12	0	0
	RBT400284-M-3	12	0	0
	RBT400284-M-4	12	0	0
	RBT400284-M-5	12	0	0

APP-1600-E

408947

" 48

" 49

" 50

" 51

" 52

" 53

" 54

" 55

RBT400284-M-2 (Foam)

408917

" 18

" 19

" 20

" 21

" 22

" 23

" 24

" 25

" 26

" 27

RBT400284-M-3

5108928

" 29

" 30

" 31

" 32

" 33

" 34

" 35

" 38

DART
AEROSPACE

Container No: S118170



Part: RBT400284-M

Job No: 181872

Serial No/Batch: S118170

Revision: A

Inspector:

Exp Date:

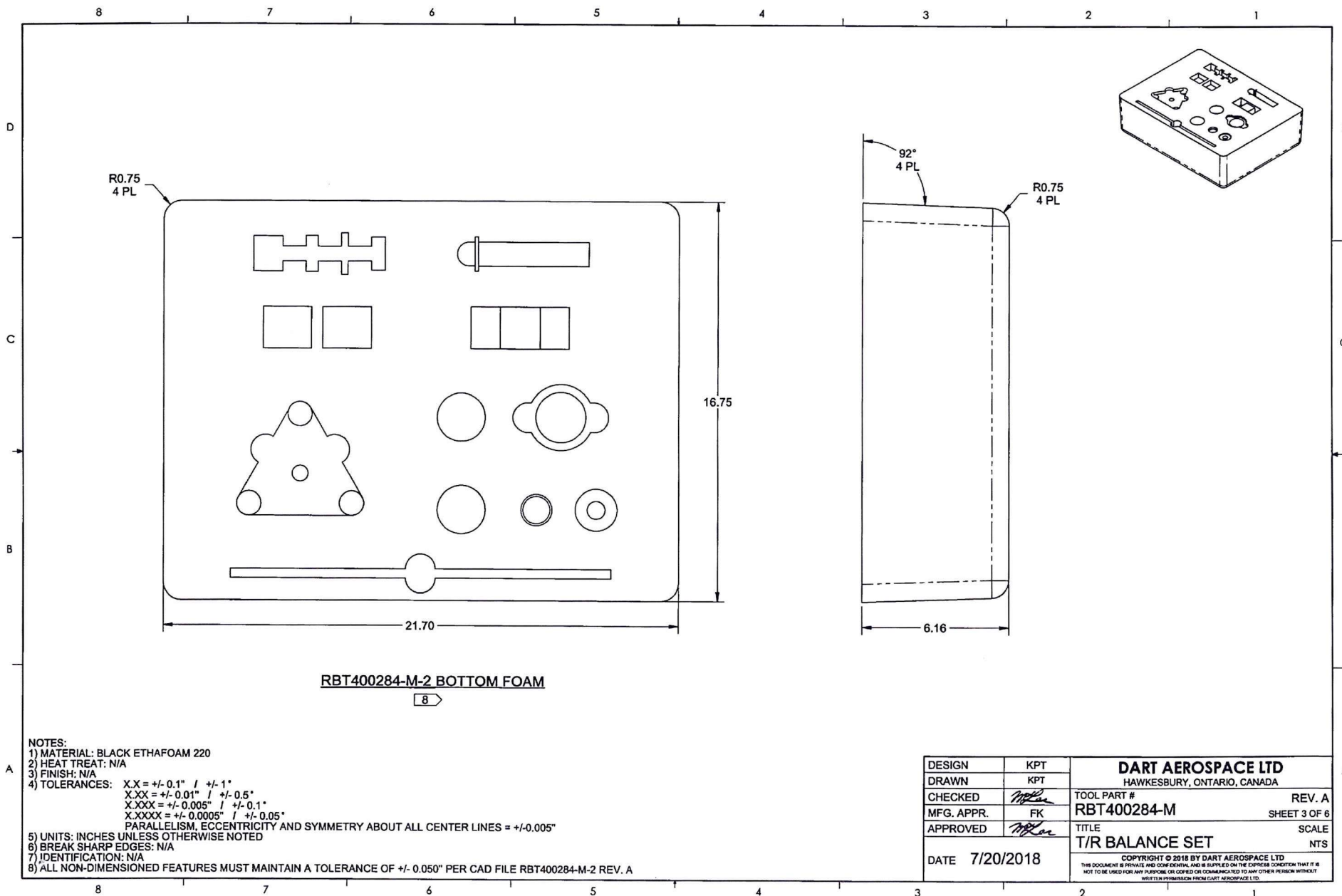
Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/15/18

Part Specifications	
Specifications could not be found.	

Plex 8/10/18 10:47 AM dart.Lussier.Patrick

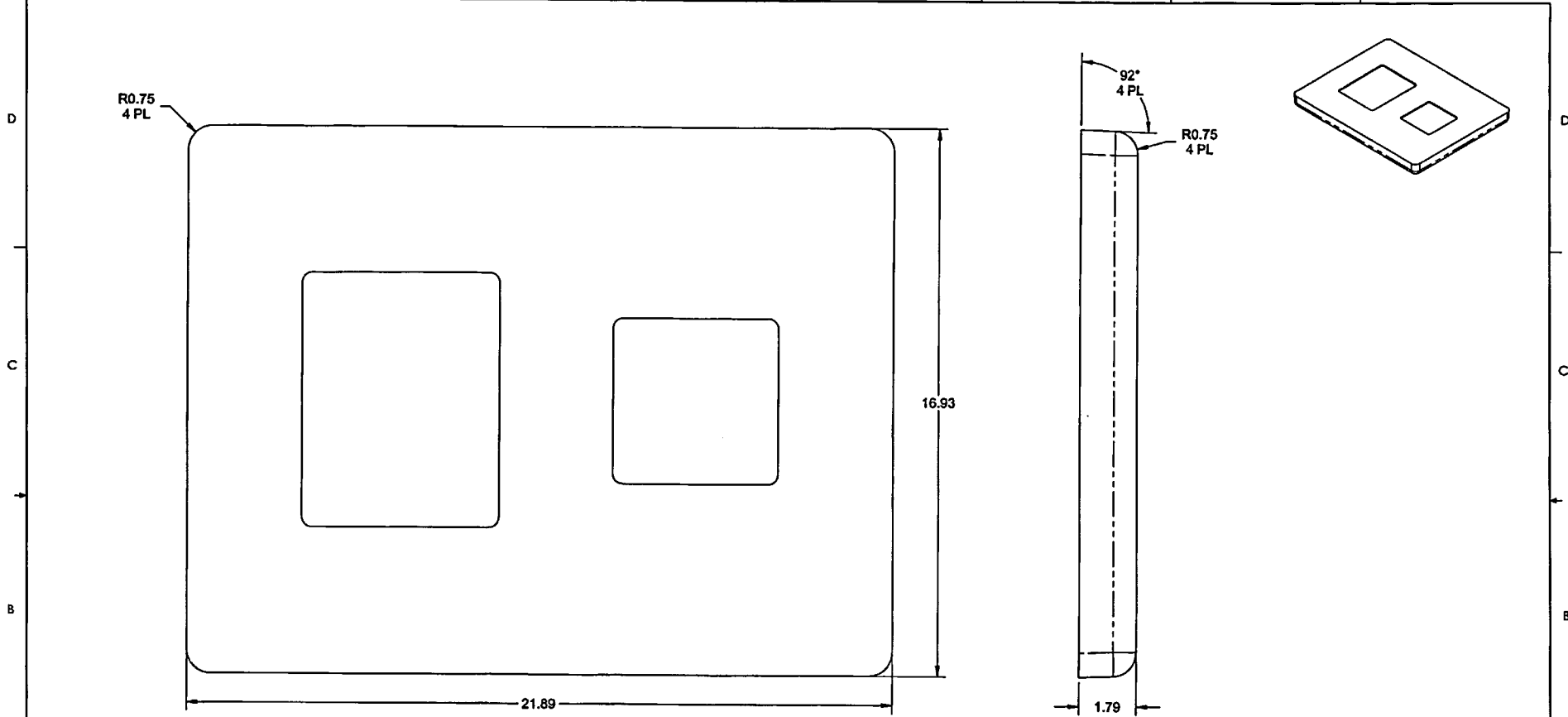


NOTES:

- 1) MATERIAL: BLACK ETHAFOAM 220
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
X.XX = +/- 0.01" / +/- 0.5"
X.XXX = +/- 0.005" / +/- 0.1"
X.XXXX = +/- 0.0005" / +/- 0.05"
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RBT400284-M-2 REV. A

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	<i>[Signature]</i>	TOOL PART #	REV. A
MFG. APPR.	FK	RBT400284-M	SHEET 3 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
		T/R BALANCE SET	NTS
DATE	7/20/2018	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



RBT400284-M-3 TOP FOAM

8

NOTES:

1) MATERIAL: BLACK ETHAFOAM 220

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
 X.XX = $\pm 0.01"$ / $\pm 0.5"$
 X.XXX = $\pm 0.005"$ / $\pm 0.1"$
 X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: N/A

7) IDENTIFICATION: N/A

8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF $\pm 0.050"$ PER CAD FILE RBT400284-M-3 REV. A

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	<i>ML</i>	TOOL PART #	REV. A
MFG. APPR.	FK	RBT400284-M	SHEET 4 OF 8
APPROVED	<i>ML</i>	TITLE	SCALE
DATE	7/20/2018	T/R BALANCE SET	NTS
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8 7 6 5 4 3 2 1